

## WHAT IS CLAIMED IS:

1. A liquid electrophotographic toner composition comprising:
  - a) a liquid carrier having a Kauri-butanol number less than 30 mL; and
  - 5 b) a plurality of toner particles dispersed in the liquid carrier, wherein the toner particles comprise polymeric binder comprising at least one amphipathic copolymer comprising one or more S material portions and one or more D material portions, wherein the D material portion has a  $T_g$  greater than about 55°C.
- 10 2. The liquid electrophotographic toner composition according to claim 1, said toner particle comprising at least one visual enhancement additive.
3. The liquid electrophotographic toner composition according to claim 2, wherein  
15 the D material portion of the amphipathic copolymer has a  $T_g$  greater than or equal to about 65°C.
4. The liquid electrophotographic toner composition according to claim 2, wherein the amphipathic copolymer has a total calculated  $T_g$  greater than or equal to about 30°C.
- 20 5. The liquid electrophotographic toner composition according to claim 2, wherein the amphipathic copolymer has a total calculated  $T_g$  greater than or equal to about 40°C.
6. The liquid electrophotographic toner composition according to claim 2, wherein  
25 the amphipathic copolymer has a total calculated  $T_g$  greater than or equal to about 60°C.

7. The liquid electrophotographic toner composition according to claim 2, wherein the D portion of the amphipathic copolymer comprises the residue of one or more of the monomers selected from the group consisting of trimethyl cyclohexyl methacrylate; ethyl methacrylate; ethyl acrylate; isobornyl (meth)acrylate; 1,6-Hexanediol di(meth)acrylate and methyl methacrylate.
8. The liquid electrophotographic toner composition according to claim 2, wherein the S portion of the amphipathic copolymer comprises the residue of one or more of the monomers selected from the group consisting of lauryl methacrylate, 2-hydroxyethyl methacrylate, dimethyl-m-isopropenyl benzyl isocyanate, trimethyl cyclohexyl methacrylate, and ethyl hexyl methacrylate.
9. The liquid electrophotographic toner composition according to claim 3 wherein the composition has a solids content of about 8-20%.
10. A method of making a liquid electrophotographic toner composition comprising steps of:
- a) providing a dispersion of amphipathic copolymer in a liquid carrier, wherein said amphipathic polymer comprises one or more S material portions and one or more D material portions, wherein the D material portion has a  $T_g$  greater than about 55°C; and
  - b) mixing the dispersion with one or more ingredients comprising at least one visual enhancement additive under conditions effective to form a plurality of toner particles.
11. A method of electrophotographically forming an image on a substrate surface comprising steps of:
- a) providing a liquid toner composition of claim 1;
  - b) causing an image comprising the toner particles in a carrier liquid to be formed on a surface of a photoreceptor; and

c) transferring the image from the surface of the photoconductor to an intermediate transfer material or directly to a print medium without film formation on the photoreceptor.

- 5 12. The method of claim 11, wherein the liquid toner has a 25-35% solids content when the image is formed on the surface of the photoreceptor.